

Date: Friday, 22/08/2008 2:02:40 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 41602	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41555	Material :
Written By :	Due Date : 25/09/2008 Qty: 16 Um: Each
Checked & Approved By : <u>JD 08.8.22</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 6061-T6 7.0x6.5x2.0
 350 Saddle Billet
 Batch: B41962

JD 08/10/17

(16)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 41602 Double check by: JD

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Debur
- 5-Tumble to remove sharp edges.

JD 08/10/17

S.F 08/10/18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JD 08/10/18

4.0	QC8	SECOND CHECK
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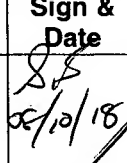
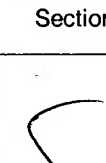
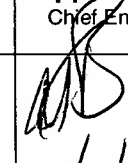
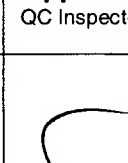


Comment: SECOND CHECK

JD 08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3500-1 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/10/22
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41602</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/18	2.0	One part found on table after shift Rotation with a mark on the Island near from the hole.	 08/10/20	SCRAP PART. <u>08/10/20</u> THICKNESS WOULD BE TOO SMALL IF FACED FURTHER. Give to marking the show	 08/10/18	 08/10/20	 08/10/20	 08/10/20
		R.C. Mape when the part was fixed on the 3 rd operation have a chip of metal under. Chip Depth is 0.010".						

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 41602

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

08-10-20 (X16)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45
320°F
4:15

MS 08/10/20

(16X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS 08/10/21

(16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST432

MS 08/10/21 (X16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22

Job Completion



MS 08-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41602
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.487	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.149	3.149	3.149	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		0.375	.373	.373	.373		
F	0.490	0.510		0.500	.500	.500	.500		
H	R.470	R.530		0.525	.525	.525	.525		
I	R1.575	R1.595		1.5775	1.579	1.579	1.579		
J	0.240	0.260		.245	.252	.252	.252		
K	0.490	0.510		0.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		0.320	.320	.320	.320		
N	0.256	0.262		0.259	.258	.258	.258		
O	6.500	6.520		6.500	6.500	6.500	6.500		
P	5.990	6.010		6.020	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.500	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.540	.540	.550	.550		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.100	.100	.110	.110		
AA	R1.125	R1.145		1.130	1.130	1.130	1.130		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.630	.630	.630	.630		
AD	0.240	0.260		.240	.250	.250	.250		
AE	1.810	1.830		1.820	1.820	1.820	1.818		
AF	0.240	0.260		0.250	.250	.250	.250		
AG	0.140	0.160		0.153	.153	.153	.153		
AH	0.140	0.160		.150	.158	.158	.158		
AI	0.140	0.160		.148	.158	.158	.158		
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 08/10/17

Audited by: <i>[Signature]</i>
Date: 08/10/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 411002
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	54	62	73	84	By	Date
A	0.483	0.490		.486	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.374	.374	.374	.374		
F	0.490	0.510		.503	.503	.502	.502		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.253	.253	.253	.253		
K	0.490	0.510		.498	.498	.499	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.630	.630	.630		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.820	1.818	1.818	1.818		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.159	.152	.152	.152		
AH	0.140	0.160		.150	.160	.160	.160		
AI	0.140	0.160		.160	.150	.150	.150		
Accept/Reject									

Measured by: <i>SB</i>
Date: <i>05/12/18</i>

Audited by: <i>JL</i>
Date: <i>05/10/20</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ <i>AK</i>	<i>AK</i>

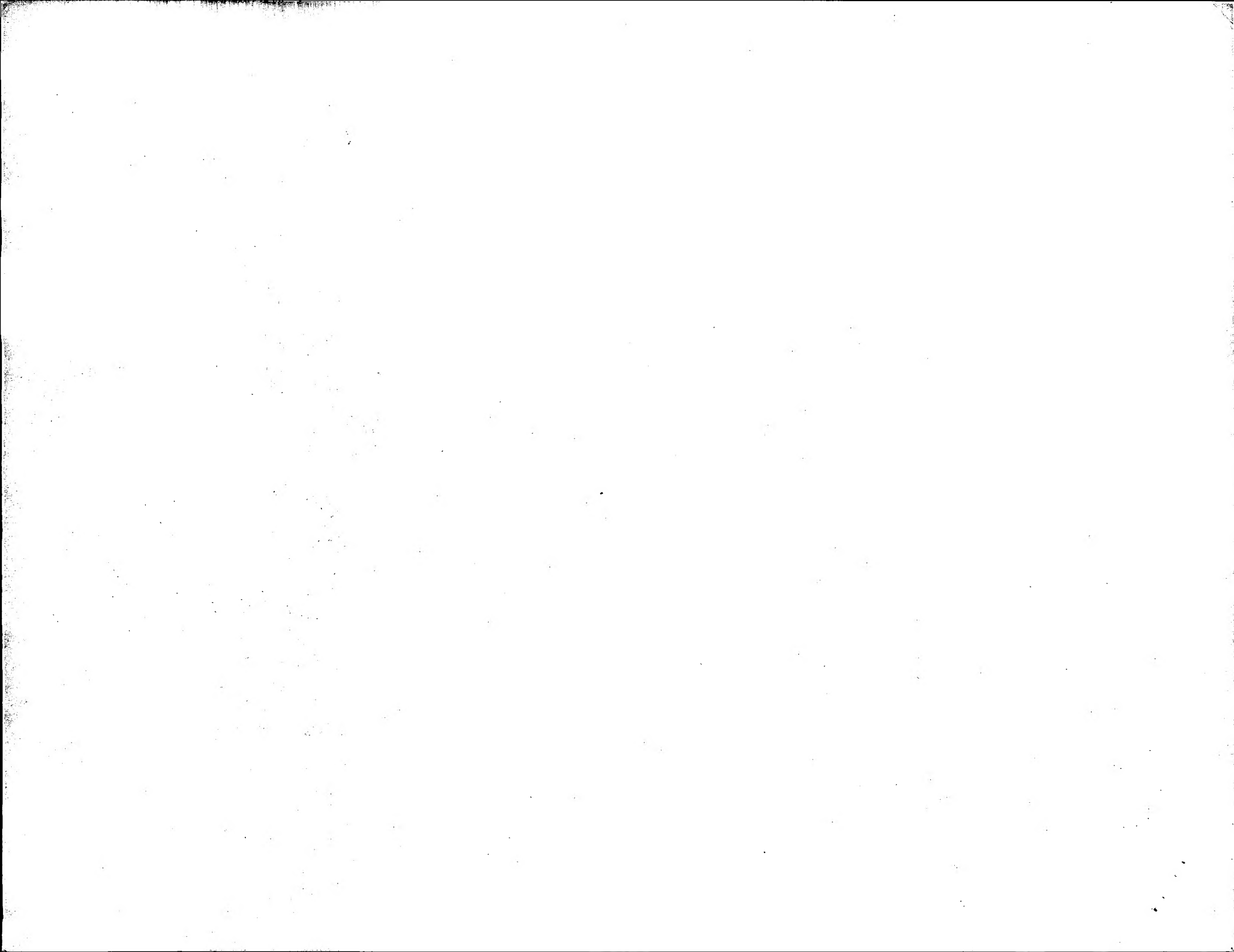
DART AEROSPACE LTD		Work Order: 41602
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	99	102	113	114	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.580	1.580	1.580	1.580		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.820	1.818	1.818	1.818		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by: <i>DS</i>
Date: 08/10/14

Audited by: <i>JL</i>
Date: 08/10/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<i>[Signature]</i>



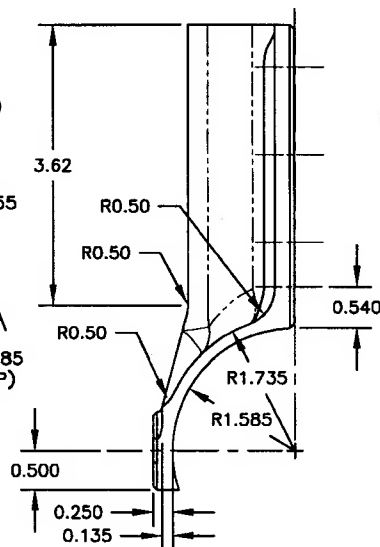
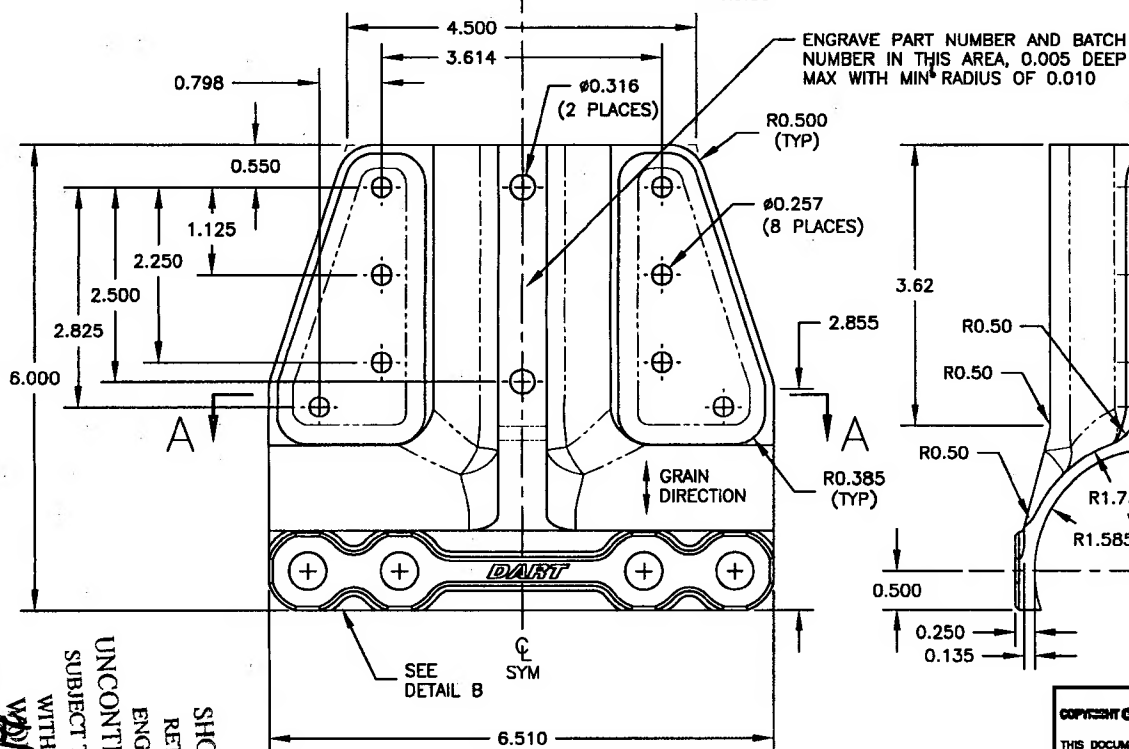
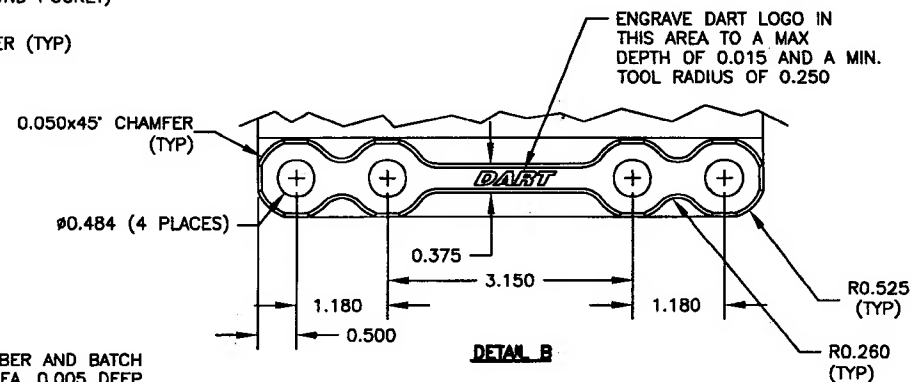
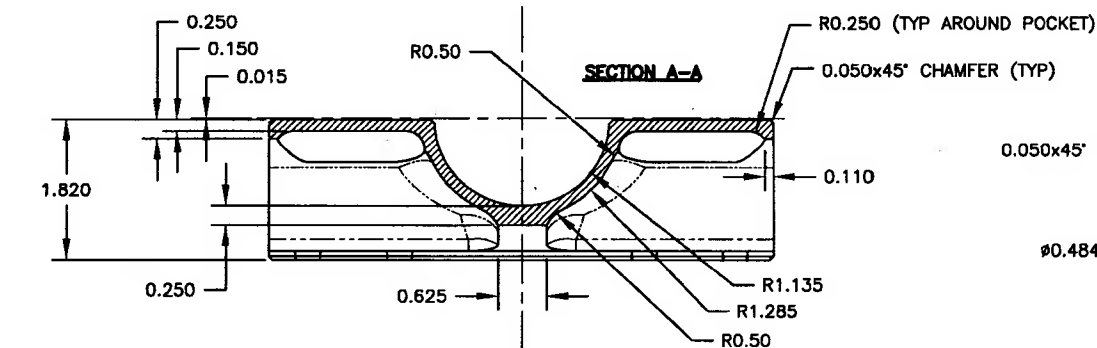
DART AEROSPACE LTD		Work Order: 41602
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	14	15	16	18		
A	0.483	0.490	.485	.485	.485	.485			
B	1.175	1.185	1.175	1.178	1.178	1.178			
C	3.145	3.155	3.150	3.150	3.150	3.150			
D	1.175	1.185	1.175	1.178	1.178	1.178			
E	0.365	0.385	.375	.375	.375	.375			
F	0.490	0.510	.500	.500	.500	.500			
H	R.470	R.530	.500	.500	.500	.500			
I	R1.575	R1.595	1.585	1.585	1.585	1.585			
J	0.240	0.260	.250	.250	.250	.250			
K	0.490	0.510	.500	.500	.500	.500			
L	3.590	3.650	3.620	3.620	3.620	3.620			
M	0.315	0.320	.320	.320	.320	.320			
N	0.256	0.262	.258	.258	.258	.258			
O	6.500	6.520	6.510	6.510	6.510	6.510			
P	5.990	6.010	6.000	6.000	6.000	6.000			
Q	2.820	2.830	2.825	2.825	2.825	2.825			
R	2.495	2.505	2.500	2.500	2.500	2.500			
S	2.245	2.255	2.250	2.250	2.250	2.250			
T	1.120	1.130	1.125	1.125	1.125	1.125			
U	0.540	0.560	.550	.550	.550	.550			
V	0.793	0.803	.798	.798	.798	.798			
W	R.240	R.260	.250	.250	.250	.250			
X	0.040	0.060	.050	.050	.050	.050			
Y	0.100	0.120	.110	.110	.110	.110			
AA	R1.125	R1.145	1.135	1.135	1.135	1.135			
AB	R.490	R.510	.500	.500	.500	.500			
AC	0.615	0.635	.625	.625	.625	.625			
AD	0.240	0.260	.250	.250	.250	.250			
AE	1.810	1.830	1.820	1.820	1.820	1.820			
AF	0.240	0.260	.250	.250	.250	.250			
AG	0.140	0.160	.150	.150	.150	.150			
AH	0.140	0.160	.160	.160	.160	.160			
AI	0.140	0.160	.150	.150	.150	.150			
Accept/Reject									

Measured by:	JL
Date:	08/10/19

Audited by:	JL
Date:	08/10/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JL



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	9P	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C SHEET 1 OF 1
DART AEROSPACE LTD.		SCALE 2:3

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